

End Rounding Die for CTJM-1 Jacket Maker Kit

Type: -M -S -H

Tubing Diameter: _____



The End Rounding or Jacket Maker die is the FIRST STEP in turning a piece of cut tubing into a bullet jacket. Its purpose is to round over the end of the tube. To do this, you must use a punch that fits the ID of the tube snugly, and is about 1/2 caliber shorter than the tubing. That is, if you are using 3/8-inch tubing, then the tube should be cut about 3/16 inch longer than the punch (from shoulder to tip).



Type: -M -S -H

Tubing Diameter: _____

Tubing Wall: _____

Tubing Length: _____



This punch is used in the End Rounding Die (Jacket Maker or J) to roll over the end of the tubing. The length of the punch tip should be about half the tubing diameter shorter than the proper tube length. That is, for 1/2-inch tubing, the tube should be about .25 inches longer than the punch tip.

For 3/8 tubing, the tube should be cut about 3/16 inch longer than the punch tip. For 5/16, cut the tubing about 5/32 longer. For 1/4, cut the tubing about 1/8 inch longer. Somewhat more does not hurt, but less prevents the end from

closing because there is not enough length to close over the end of the punch. Too much causes the tubing to buckle rather than fold neatly.



Type: -M -S -H

Caliber:

Wall thickness: _____



How to make a copper tubing bullet... Step 4. Form BT-shape in Step 6. Tools required: CTJM-1 tubing jacket maker, Alternate Step 5. Step 5. BT-1 die for RBT Form the Seat Core in BT-2 Seat Core in plus a bullet swaging die set (FJFB-3, RBTO-4) bullets. or flatten ogive. die for RBT CS-2 for flat the end in CS-1 bullets. base bullets. die for flat base Step2. Step 1. bullets. Anneal the Round the end in the tubina! JM die. Tube Step 3. lenath is Draw the 1/4-inch tube to more than Annealing the tubing can be size. done by heating briefly to red punch tip. (950-1200 degrees F.) with a Use RBT propane torch, heat treatpunch only for RBT ment furnace, or other Punch for RBT bullets bullets: use means. If the tubing is alis shaped like a flat punch ready annealed when you boattail bullet, and for flat-base buy it, this step is not reforces the jacket to bullets. take on the BT shape quired. Straight lengths of (the rebate is formed hard drawn tubing must be in the next die, BT-2, annealed! during core seating). The Jacket Reducing Die Punch for the flat is used to bring the stanbase bullet is flat on dard tubing diameter (from the end, and fits PF-1 1/2-inch to 1/4-inch range) inside the tubing after drawing (the similar to the size that will fit into looking end rounding the core seating or first punch fits into the boattail forming die (just a tubing *before* few thousandths under fin-BT-2 drawing). Type -H dies and punches J ished bullet size). It is not BT-1 are illustrated. The same needed for .50 BMG using or operation holds for type -M CS-1 1/2-inch tubing. and -S sets. Jacket-maker die is also called Depending on whether you use a flat base or rebated boattail (RBT) design, you will use an "end flattening" punch to finish closing the end of the

tube and /or to shape the boattail angle. The lead core is then inserted

and swaged with a shorter core seating punch, either in the same core

seat die (flat base) or in the BT-2 forming die (RBT base).

Jacket-maker die is also called the "end rounding" die, because it rounds the end of the tubing, providing that the tubing is at least 1/4-inch longer than the punch tip.